

Lid only

Ship March 20

Work Order ID 113478

113478

Page 1

February-19-14 8:11:09 AM

Item ID: D350-607-417

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits LH or RH

Stop

NS2

Start Date: 2/19/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/03/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Per Hour	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-607-3	D								

100

0.00

100

DOCUMENT CONTROL

DC

Memo *M. H.*

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-607-417 CHG004

14-228

MLJ 14-02-28

104

0.00

104

Small Fab

Memo

0.00

Small Fab

Assemble lid as per dwg D4032 sheet 3 of 3, section C-C, view F-F.

1 < f M 14/02/27

106

QC5- Inspect part completeness to step on W/O

0.00

106

QC

Memo

0.00

Quality Control

1 M 14.02.27

7
3

Work Order ID 113478

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113478

Page 2

Item ID: D350-607-417

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits LH or RH

Start Date: 2/19/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/03/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DD350-607-417								
	Location: _____								
	PPP rev: _____								

DAS
31
9-89

1x

DAS
28
9-89

14-02-25

14-2-28 (K)

DAS
6
9-89

DAS
6
9-89

14-2-28

BK 002

Work Order ID 113478

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113478

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Item ID: D350-607-417

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits LH or RH

Start Date: 2/19/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/03/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center ID
140Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp***140***

QC

Memo

0.00

Quality Control

14-03-3

14-03-03

Work Order Summary

February-19-14 8:34:26 AM

Page 1 of 1

Criteria : Work Order ID: 108513 Item ID: D3212-1 Product Family SMALL FAB
 Work Order Start Dates 10/17/13 to 10/17/13 11:59:59 PM Work Order Required Dates 10/17/13 to 10/17/13
 11:59:59 PM

All References
 Work Order Status Released

Work Order ID	108513	Required Qty	4.0000	Status Code	Released
Item ID	D3212-1	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Replacement Interior Window For -015 & -025				
Current Acct Value	\$104.041				

Start Date	10/17/13	Required Date	10/17/13	Completed Date	
------------	----------	---------------	----------	----------------	--

Standard	** Actual **		** Acct. Value **		** Variance **	** Variance % **
	Total	Each	Each	Each	Each	Each
Direct Costs						
Material	\$11.181	\$0.000	\$2.866	\$2.866	100.00%	
Labor	\$6.773	\$0.000	\$18.895	\$18.895	100.00%	
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%	
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%	
Fixed Burden	\$19.220	\$0.000	\$41.708	\$41.708	100.00%	
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%	
** Total **	\$37.174	\$0.000	\$63.470	\$63.470		

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
MACRLICS.125 1/8" Polycast II Sheet	4.1032		2/11/14	4.5000	\$11.181
Total Matl Amts:					\$11.181

Work Center Waterjet

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
MACL01	100	1/05/14										
			0.00	0.00	0.11	0.11	1.00	\$0.000	\$2.110	\$5.356	\$0.000	\$7.46
	100	2/11/14										
			0.00	0.00	0.23	0.23	1.00	\$0.000	\$4.663	\$13.864	\$0.000	\$18.52
Total:			0.00	0.00	0.34	0.34	2.00	\$0.000	\$6.773	\$19.220	\$0.000	\$25.99

Picklist Print

February-19-14 8:11:08 AM

Page 1

Work Order ID: 113478

113478

Parent Item: D350-607-417

D350-607-417

Parent Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits LH or RH

Start Date: 2/19/14

Required Date: 3/03/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV: A NEW ISSUE JLM 10-04-15 VERIFIED BY:DD IPP Rev:B
as per ecn 10-552 DD 10.04.19 verified by:EC IPP REV:C 10.087.26 part
list chg per ECN 10-596 DD verf:EC IPP Rev:D 13.07.08 as per CHG003
(ECN13-582) DD verf:JLM IPP REV:E 14.02.03 D350-607-3 REV.D DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-20A Bolt		Purchased	No			104	Each	72.0000	2	2		DAS 28 9-89	14-02-25
AN3-20A													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST352			72						
				117441			72		2x				
AN5-21A Bolt		Purchased	No			104	Each	52.0000	2	2		DAS 28 9-89	
AN5-21A													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST337			52						
				124215			2						
				M126175			50		2x				
D2530 Handle Weldment		Manufactured	No			104	Each	5.0000	1	1		DAS 28 9-89	
D2530													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST255			5						
				97661			5		1x				

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Work Order ID: 113478

113478

Parent Item: D350-607-417

D350-607-417

Parent Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits LH or RH

Start Date: 2/19/14

Required Date: 3/03/14

D2535

Manufactured No

104 Each

Start Qty: 1.00
119.0000 2 2

Required Qty: 1.00

D2535

Spring

**

DAS
28
9-89

14-02-25

Location

Loc Qty

Loc Code

ST011

119

100552

69

110374

50

2x

D2537

Manufactured No

104 Each

93.0000 2 2

D2537

Bushing

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST011

93

102982

4

103608

23

103861

42

110274

24

2x

D4086-215

Manufactured No

110 Each

10.0000 1 1

D4086-215

Placard Max Load

**

14-02-27

Location

Loc Qty

Loc Code

ST091

10

110331

10

B110331

2x

D4086-220

Manufactured No

110 Each

14.0000 1 1

D4086-220

Placard

**

DAS
28
9-89

14-02-28

Location

Loc Qty

Loc Code

ST091

14

84149

14

1x

DAS
6
9-89

DAS
31
9-89

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Work Order ID: 113478

113478

Parent Item: D350-607-417

D350-607-417

Parent Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits
LH or RH

Start Date: 2/19/14

Required Date: 3/03/14

D4917-315

Manufactured No

110

Each

20.0000

Start Qty: 1.00

Required Qty: 1.00

D4917-315

Placard, Max Load

DAS
6
9-89

Location

Loc Qty

Loc Code

ST126

12

112251

12

ST127

8

110574

8

D4917-320

Manufactured No

110

Each

20.0000

D4917-320

Placard, Max Load

DAS
6
9-89

Location

Loc Qty

Loc Code

ST126

12

112209

12

ST127

8

110575

8

MS21042L3

Purchased No

104

Each

3,946.000

MS21042L3

Nut

DAS
9-89

Location

Loc Qty

Loc Code

ST314

2991

M127410

2940

M127831

41

xxxxx

10

ST506

955

123900

955

**

**

**

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

14-02-28

DAS
31
9-89

DAS
31
9-89

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Work Order ID: 113478

113478

Parent Item: D350-607-417

D350-607-417

Parent Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits
LH or RH

Start Date: 2/19/14

Required Date: 3/03/14

MS21042L5 Purchased No 104 Each 966.0000 Start Qty: 1.00 2 2

MS21042L5

Nut

**

DAS
28
9-89

14-02-25

Location Loc Qty Loc Code

GA 5

117611 5

ST315 461

m127304 461

ST509 500

m127813 500

2x

NAS1149F0563P Purchased No 104 Each 437.0000 2 2

NAS1149F0563P

Washer

**

DAS
28
9-89

Location Loc Qty Loc Code

ST295 437

121350 437

2x

D3915-041 Manufactured No 104 Each 0.0000 1 1

D3915-041

Light Lid Assembly, Long Basket

D3917-3

Manufactured No 110 Each 157.0000 6 6

D3917-3

Washer

**

DAS
28
9-89

14-02-28

Location Loc Qty Loc Code

ST070 157

104859 71

109114 86

6x

DAS
6
9-89

DAS
31
9-89

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Work Order ID: 113478

113478

Parent Item: D350-607-417

D350-607-417

Parent Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits LH or RH

Start Date: 2/19/14

Required Date: 3/03/14

D3953-9

Manufactured No

110 Each

Start Qty: 1.00
60.0000 1

Required Qty: 1.00

D3953-9
Gas Spring Washer

DAS 28 14-02-28
9-89

DAS 6 9-89

Location	Loc Qty	Loc Code
ST075	60	
102166	20	
107922	18	
112486	18	
94719	4	

1x

DAS 31 9-89

AN4-12

Purchased No

110 Each

90.0000 3

AN4-12
Bolt

DAS 28 9-89

DAS 6 9-89

Location	Loc Qty	Loc Code
ST356	90	
m125709	40	
m127817	50	

3x

DAS 31 9-89

AN310-4

Purchased No

110 Each

64.0000 3

AN310-4
Nut

DAS 28 9-89

DAS 6 9-89

Location	Loc Qty	Loc Code
ST342	64	
M126872	39	
M127815	25	

3x

DAS 31 9-89

AN310C4

Purchased No

110 Each

100.0000 2

AN310C4
Nut

DAS 28 9-89

DAS 6 9-89

Location	Loc Qty	Loc Code
ST342	100	
M125952	50	
M127817	50	

2x

DAS 31 9-89

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1919

1919

Picklist Print

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Work Order ID: 113478

113478

Parent Item: D350-607-417

D350-607-417

Parent Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits
LH or RH

Start Date: 2/19/14

Required Date: 3/03/14

MS24665-151

Purchased

No

110

Each

105.0000

Start Qty: 1.00

Required Qty: 1.00

3

MS24665-151
Cotter Pin

**

DAS
28
9-89 14-02-28

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

29

17566

29

ST323

76

125646

2

m127305

74

86.0000

110

Each

**

DAS
28
9-89

MS24665-300

Purchased

No

MS24665-300
COTTER PIN

Location

Loc Qty

Loc Code

GA

30

118234

30

ST299

56

124555

56

5,010.000

110

Each

**

DAS
28
9-89

NAS1149C0432R

Purchased

No

NAS1149C0432R
WASHER

Location

Loc Qty

Loc Code

GA

1971

m125807

1971

ST292

92

119124

6

121255

7

122441

79

ST510a

2947

m126221

2947

DAS
6
9-89

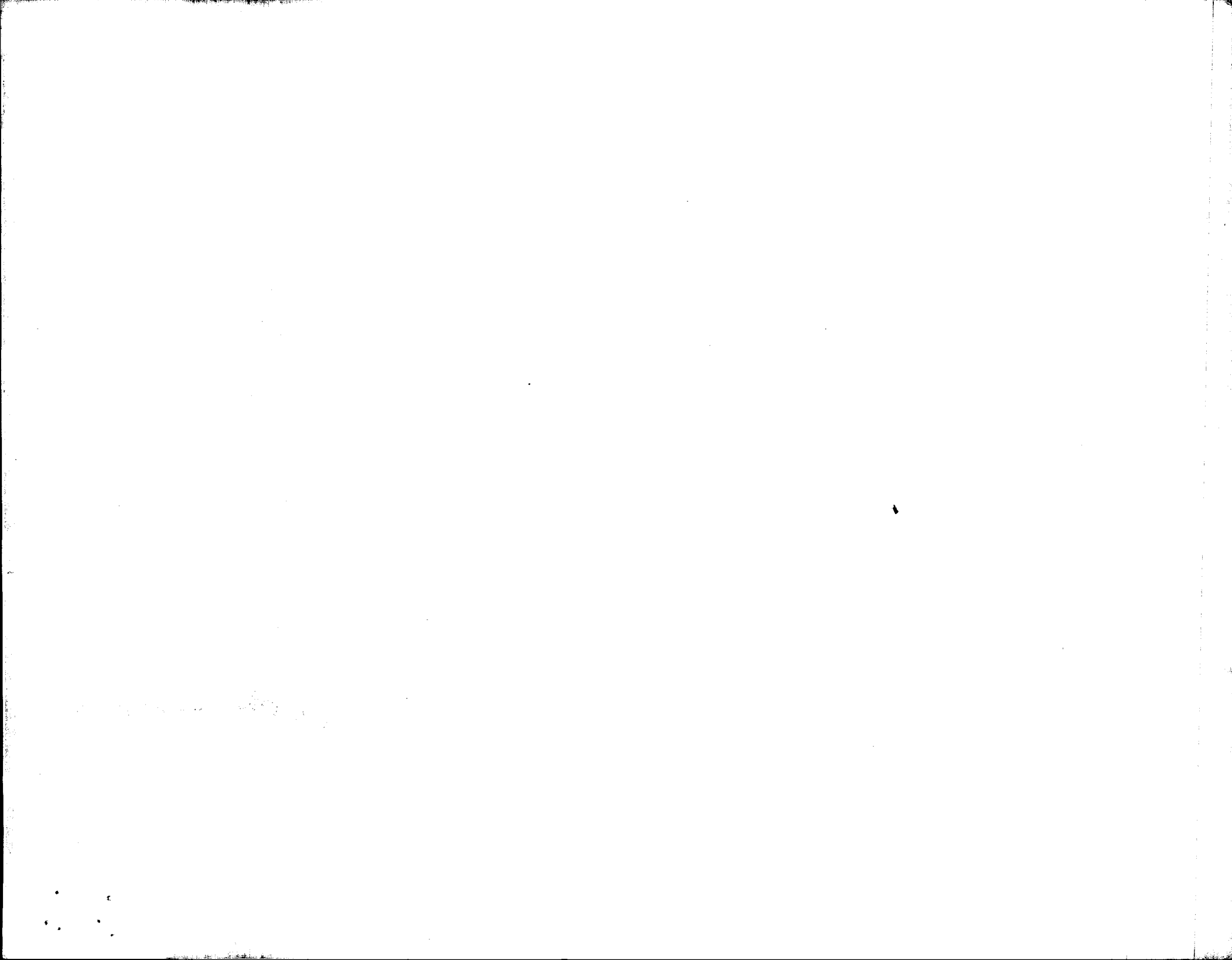
DAS
31
9-89

2x

February-19-14 8:11:09 AM

Shop Packet Print

Page 6



Picklist Print

February-19-14 8:11:09 AM

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Work Order ID: 113478

113478

Parent Item: D350-607-417

D350-607-417

Parent Item Name: Lightweight Lid Conversion, (Long) Squirrel Cheek & Spacepod Compatible Fits
LH or RH

Start Date: 2/19/14

Required Date: 3/03/14

NAS1149F0432P

Purchased

No

110

Each

984.0000

Start Qty: 1.00

Required Qty: 1.00

6 6

NAS1149F0432P

WASHER

**

DAS

28

9-89

14-02-28

DAS

6

9-89

Location

Loc Qty

Loc Code

ST295

750

M127813

750

ST510a

234

M126221

234

DAS

31

9-89

6x

3.5 INSTALLATION OF D350-607-413/-415/-417/-419 CONVERSION KITS

To replace a basket lid with a heavy duty lid or a lightweight lid using the D350-607-413/-415/-417/-419 Kits, use the following procedure:

- 3.5.1 If desired, remove the basket from the aircraft per Section 3.3.
- 3.5.2 Open lid for ease of removal of D3969-3 Gas Spring while fully extended.
- 3.5.3 Remove MS24665-300 Cotter Pin and detach end of D3969-3 Gas Spring mounted to the existing lid by unfastening AN310C4 Castellated Nuts. Retain D3953-3 Gas Spring Stud and D3953-7 Gas Spring Spacer and D3953-9 Gas Spring Washer. Refer to Figures 2, 3 and 6 as applicable.
- 3.5.4 Remove lid by removing qty (3) MS24665-151 Cotter Pins and unfastening qty (3) each AN310-4 Castellated Nuts, AN4-12 Bolts and washers.
- 3.5.5 Install D3914-041 or D3915-041 or D4018-041 or D4019-041 as applicable using qty (3) each AN310-4 Castellated Nuts and AN4-12 Bolts and qty (6) NAS1149F0432P Washers per Figure 6. Secure Castellated Nut with MS24665-151 Cotter Pins per MS33540 or AC43.13 Chapter 7.127
- 3.5.6 Attach loose end of D3969-3 Gas Spring to new lid using D3953-3 Gas Spring Stud and D3953-7 Gas Spring Spacer (removed at Step 3.5.3), D3953-9 Gas Spring Washer, NAS1149C0432R Washer and AN310C4 Castellated Nuts per Figures 2, 3 and 6 as applicable. Secure Castellated Nut with MS24665-300 Cotter Pin per MS33540 or AC43.13 Chapter 7.127.
- 3.5.7 Install D4086-X or D4917-X Placard, Max Load as applicable in accordance with Table 2 (see Section 3.1.6) and at the location shown in Figure 4.
- 3.5.8 If basket was removed from aircraft, re-install per section 3.4
- 3.5.9 Update the aircraft log book to indicate installation of the converted D350-607-4XX kit and adjust weight and balance record for the aircraft with the weight and balance data provided in Section 4.0 of this document.

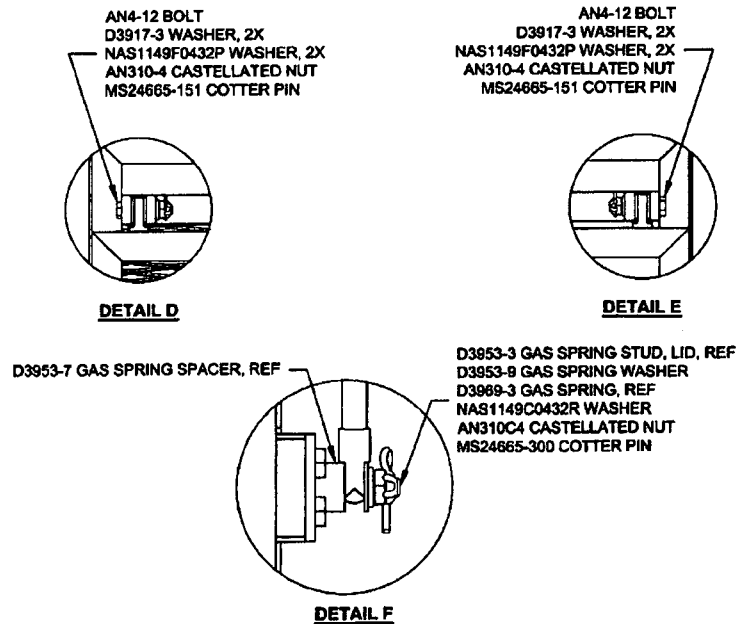


FIGURE 6: D350-607-413/-415/-417/-419 CONVERSION KITS
DETAIL VIEWS FROM FIGURES 2 AND 3

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Revision: **D**
Date: 14.01.02

6.0 CONVERSION & OPTIONAL KITS PARTS LIST

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT
1	1	1	1		D2530	HANDLE ASSEMBLY
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D3501-1	BUSHING
				2	D3910-5	X-TUBE LUG
1					D3914-041	LONG BASKET LID ASSEMBLY
		1			D3915-041	LONG BASKET LID ASSEMBLY (LIGHTWEIGHT)
6	6	6	6		D3917-9	WASHER
1	1	1	1		D3953-9	GAS SPRING WASHER
				4	D3984-030	RUBBER EXTRUSION, X-TUBE
	1				D4018-041	SHORT BASKET LID ASSEMBLY
			1		D4019-041	SHORT BASKET LID ASSEMBLY (LIGHTWEIGHT)
1					D4086-200	PLACARD, MAX LOAD
1					D4086-210	PLACARD, MAX LOAD
	1	1			D4086-215	PLACARD, MAX LOAD
			1		D4086-220	PLACARD, MAX LOAD
			1		D4086-232	PLACARD, MAX LOAD
				2	D4086-243	PLACARD, MAX LOAD
				2	D4775-041	STRUT ASSEMBLY
				2	D4776-3	SKIDTUBE CLEVIS
1				1	D4917-300	PLACARD, MAX LOAD
1				1	D4917-310	PLACARD, MAX LOAD
		1		1	D4917-315	PLACARD, MAX LOAD
	1	1		1	D4917-320	PLACARD, MAX LOAD
	1		1	1	D4917-332	PLACARD, MAX LOAD
2	2				AN3-16A	BOLT
		2	2		AN3-20A	BOLT
3	3	3	3		AN4-12	BOLT (DRILLED)
				12	AN4-14A	BOLT
					AN4-22A	BOLT
				4	AN4-42A	BOLT
2	2				AN5-17A	BOLT
		2	2		AN5-21A	BOLT
				2	AN6-13A	BOLT
3	3	3	3		AN310-4	CASTELLATED NUT
2	2	2	2		AN310C4	CASTELLATED NUT
					AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
2	2	2	2		MS21042L5	NUT (OR MS21042-5)
				16	MS21042L4	NUT (OR MS21042-4)
				2	MS21042L6	NUT (OR MS21042-6)
3	3	3	3		MS24665-15	COTTER PIN
2	2	2	2		MS24665-300	COTTER PIN
2	2	2	2		NAS1149C0432R	WASHER
6	6	6	6	24	NAS1149F0432P	WASHER
2	2	2	2		NAS1149F0563P	WASHER
				4	NAS1149F0663P	WASHER

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Revision: D
Date: 14.01.02